

Date: Monday, 29/09/2008 11:56:20 AM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: WEARSHOE		
<b>Job Number</b>	: 42328			<b>Part Number</b>	: D353539		
<b>Estimate Number</b>	: 12729			<b>Drawing Number</b>	: D3535 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 29/09/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: B		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: SMALL /MED FAB	<b>Due Date</b>	: 15/10/2008		
<b>Previous Run</b>	: 37277			<b>Qty:</b>	12	<b>Um:</b>	Each
<b>Written By</b>							
<b>Checked &amp; Approved By</b>	: JLD 08.9.09						
<b>Comment</b>	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
<b>Comment:</b> Qty.: 0.9986 sf(s)/Unit Total : 11.9826 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 109088 HB 8-10-22			
2.0	WATER JET	FLOW WATER JET	
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B HB 8-10-22 Prog Rev: 2-Deburr if necessary HB 8-10-22			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE HB 8-10-22			
4.0	QC8	SECOND CHECK	
<b>Comment:</b> SECOND CHECK S 08/10/22 417			
5.0	BRAKE NC	NC BRAKE	
<b>Comment:</b> NC BRAKE Deburr if necessary Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 HB 8-10-22 12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 29/09/2008 11:56:20 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42328

Part Number: D353539

Job Number:



Seq. #: Machine Or Operation:

Description :

Form Joggle on brake using Jig DT8158 as per Dwg D353539

6.0 QC5

INSPECT WORK TO CURRENT STEP



*ED 08/10/22 (15)*

Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/23 X/12*

7.0 POWDER COATING

POWDER COATING



*M 106442*



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: *11:10AM*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *11:40AM*

INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 QC3



*u 08-10-23*



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-18*

*u*

*08-10-23*

*X 12*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*MF 08-10-23*

*08/10/24/08*

Job Completion



W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

DART AEROSPACE LTD	Work Order:	42328
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815 X				
32.775	+/-0.010	32.775 X				
29.275	+/-0.010	29.275 X				
25.775	+/-0.010	25.775 *				
23.250	+/-0.010	23.250 X				
19.750	+/-0.010	19.750 X				
17.750	+/-0.010	17.750 X				
14.250	+/-0.010	14.250 *				
9.500	+/-0.010	9.500 X				
4.750	+/-0.010	4.750 X				
2.000	+/-0.010	2.000 X				
5.00	+/-0.030	5.00 X				
9.00	+/-0.030	9.00 X				
28.00	+/-0.030	28.00 X				
00.188	+0.005/-0.001	.188 X				
1.885	+/-0.010	1.881 X				
0.300	+/-0.010	.306 X				
0.300	+/-0.010	.306 *				
0.038	+/-0.010	.040 *				

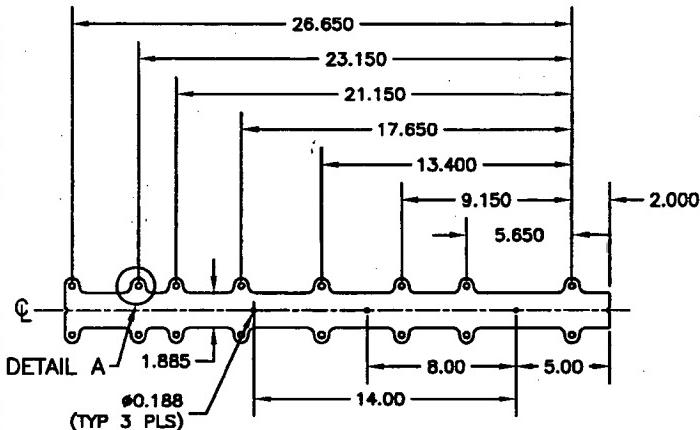
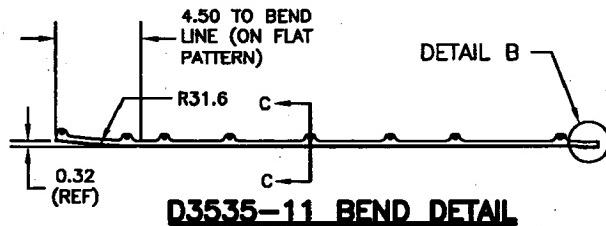
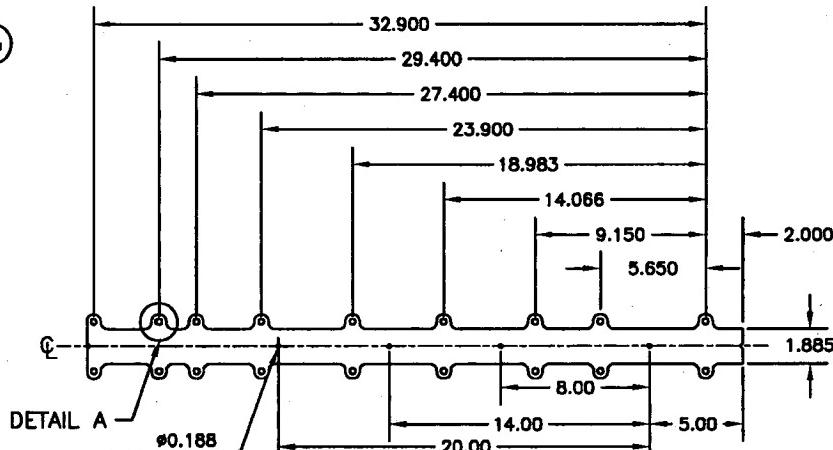
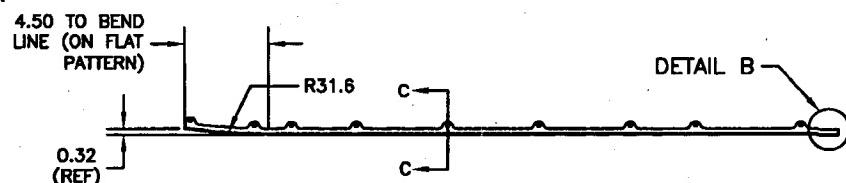
Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	8-10-22	Date:	08/10/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	R

**DART**

RELEASED

37.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK IN PROGRESS  
NO. WIP 00008

- NOTES**
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
  - PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
  - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - ALL DIMENSIONS ARE IN INCHES
  - BREAK ALL SHARP EDGES TO 0.010 MAX
  - IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>RH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		REV. B
07.04.17		SHEET 1 OF 7
A	06.10.25	SCALE
B	07.04.17	1:10
		WEARSHOE
		MOVE TAB OUTBOARD, ADD AMS SPEC

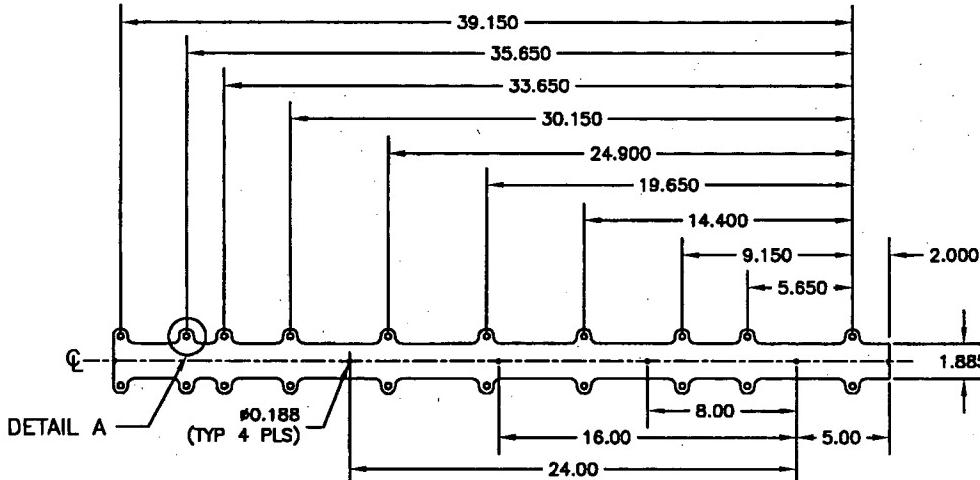
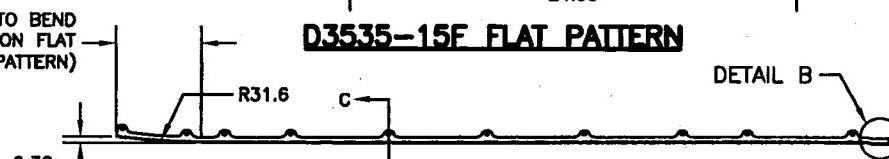
**DART**

RELEASED

07.04.24

DESIGN <b>C8</b>	DRAWN BY <b>MH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>MH</b>	APPROVED <b>MH</b>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

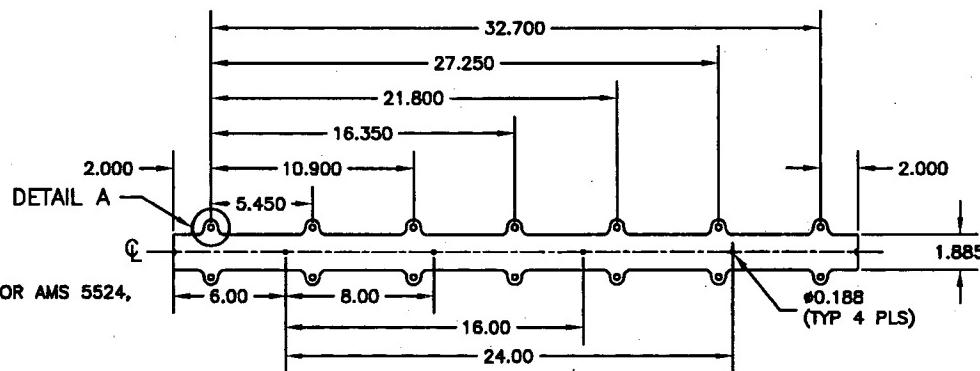
REV. B  
SHEET 2 OF 7  
SCALE  
1:10

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. U-2328

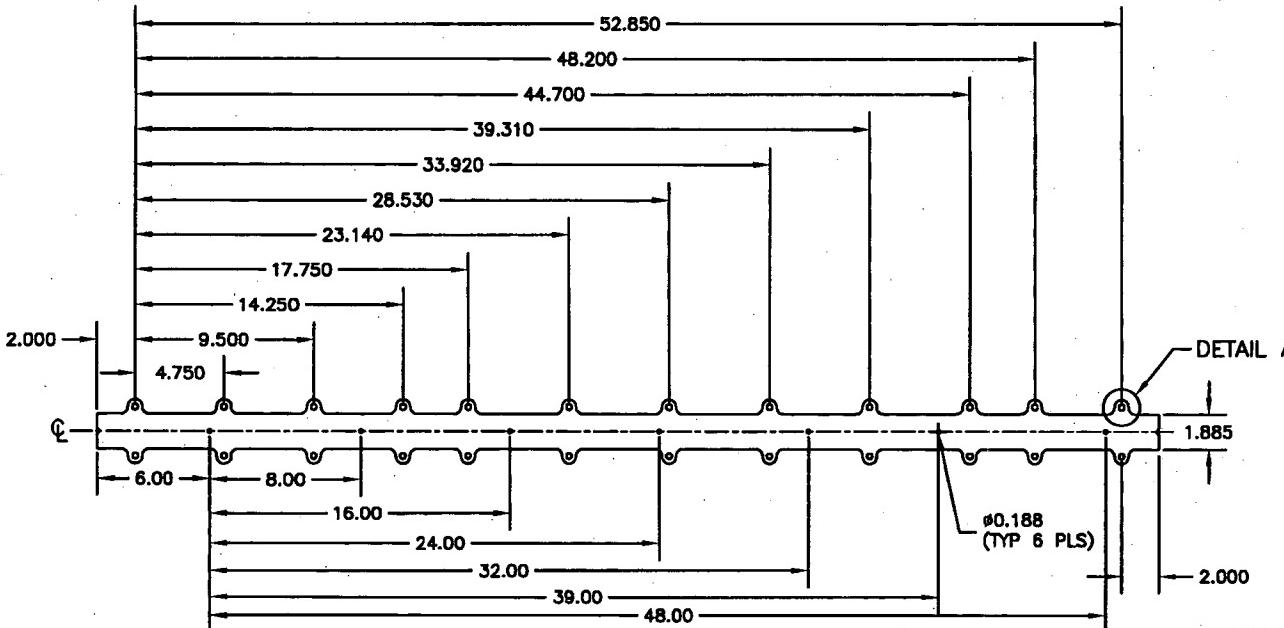
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

**DART**

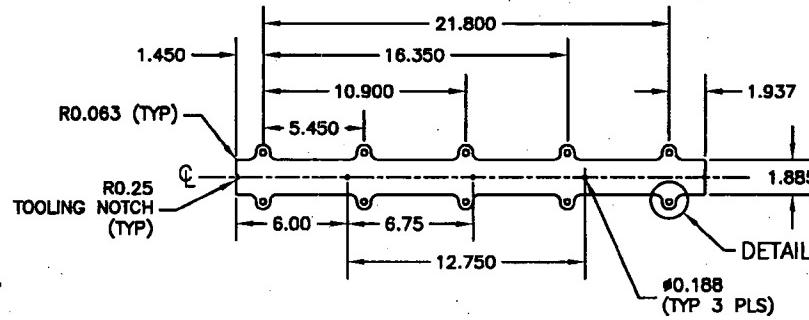
DESIGN <b>CB</b>	DRAWN BY <b>PR</b>	DART AEROSPACE USA, INC. PORT HEDLOCK, WA
CHECKED <b>H</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 3 OF 7 SCALE <b>1:10</b>

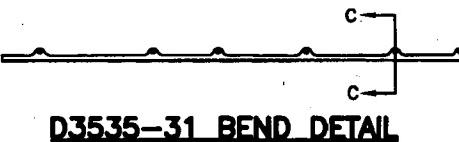
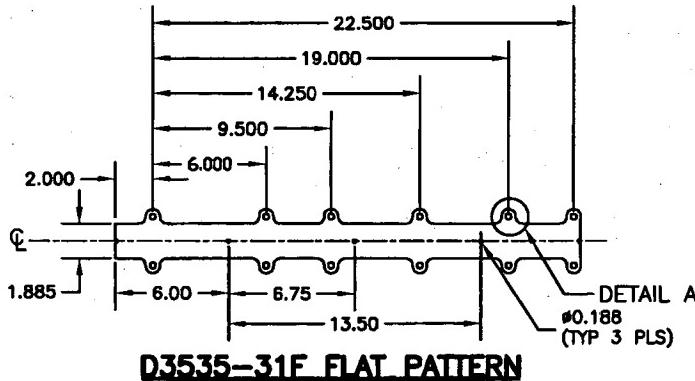
**D3535-23F FLAT PATTERN**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *W-328*

**NOTES**

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

**DART**RELEASED  
07.04.17

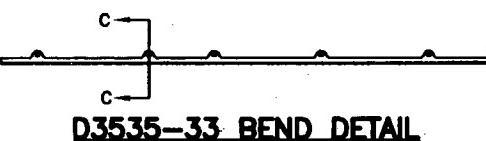
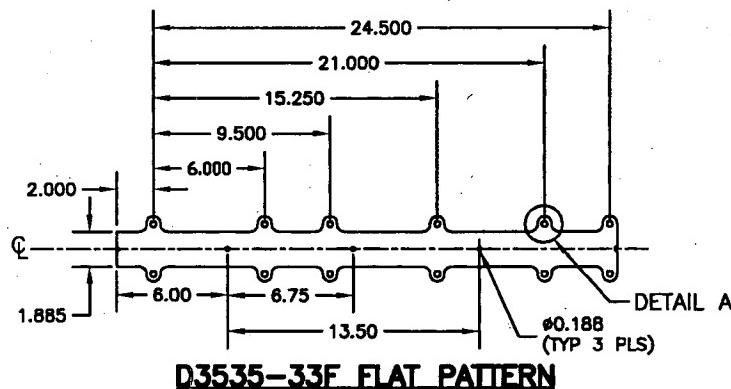
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40328

**NOTES**

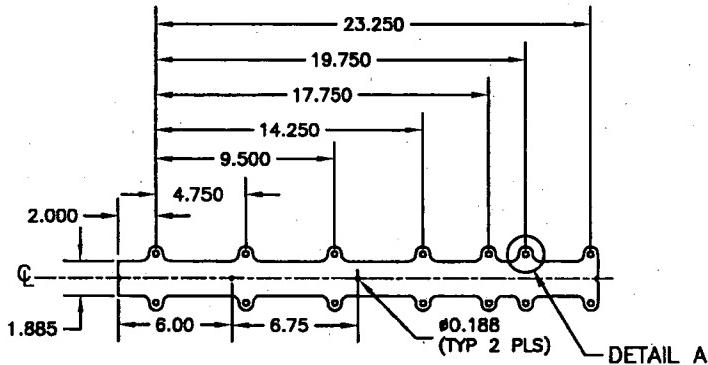
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.



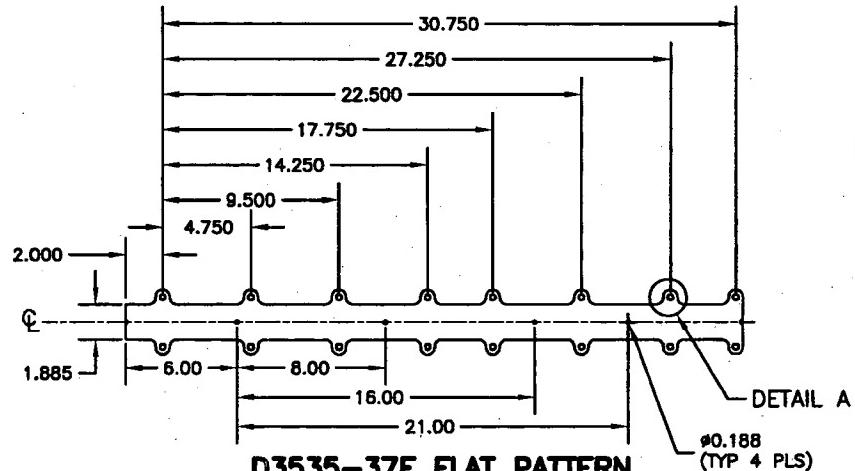
DESIGN <b>C.B</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>H</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>
		REV. B SHEET 4 OF 7 SCALE 1:10

**DART**RELEASED  
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORKS ORDER NO. W2328

**NOTES**

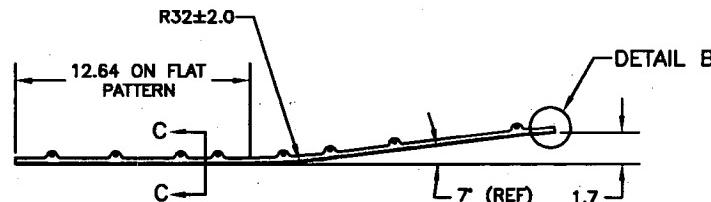
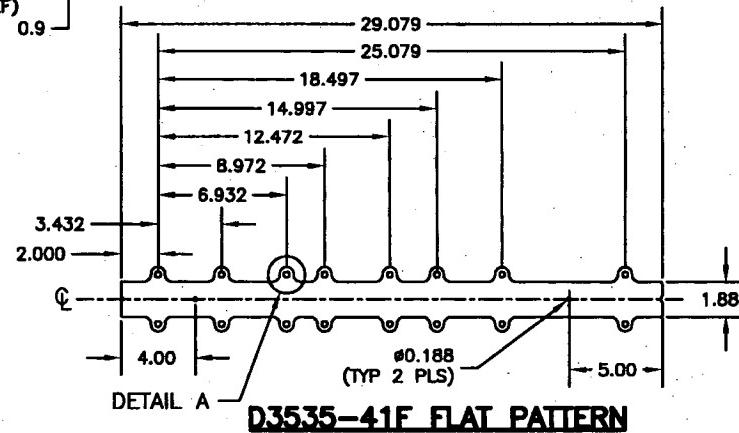
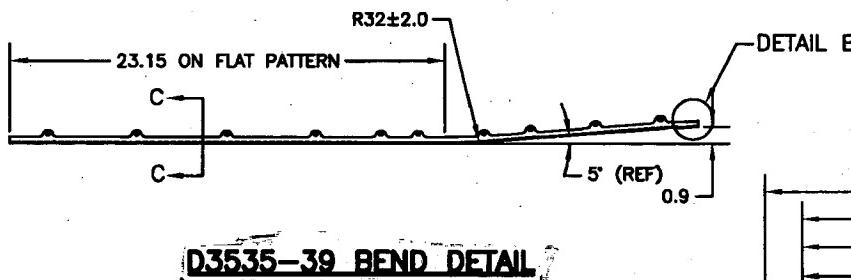
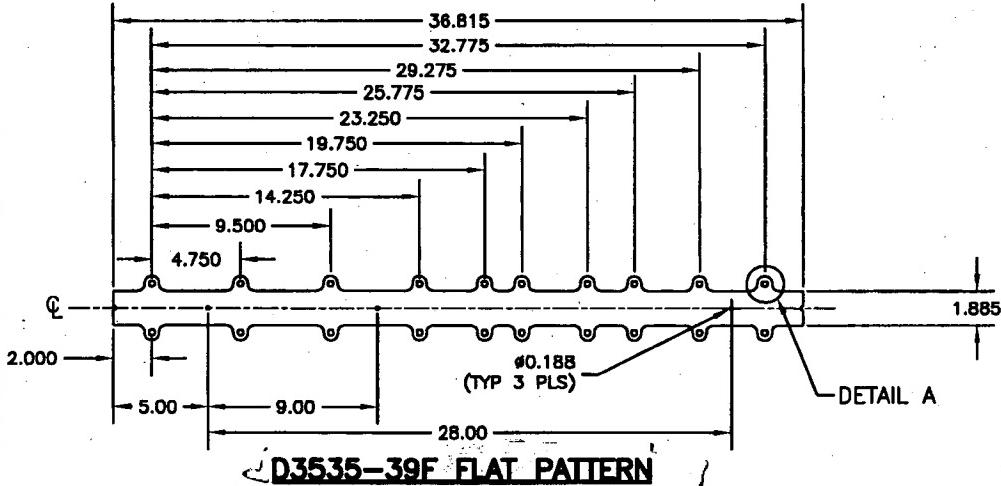
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>M</b>	PORT HADLOCK, WA
		REV. B
		D3535
		SHEET 5 OF 7
07.04.17		SCALE
		1:10

**DART**

DESIGN <b>C8</b>	DRAWN BY <b>MH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>MM</b>	APPROVED <b>MM</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SHEET 6 OF 7
SCALE <b>1:10</b>	REV. B	

RELEASED  
07.04.24

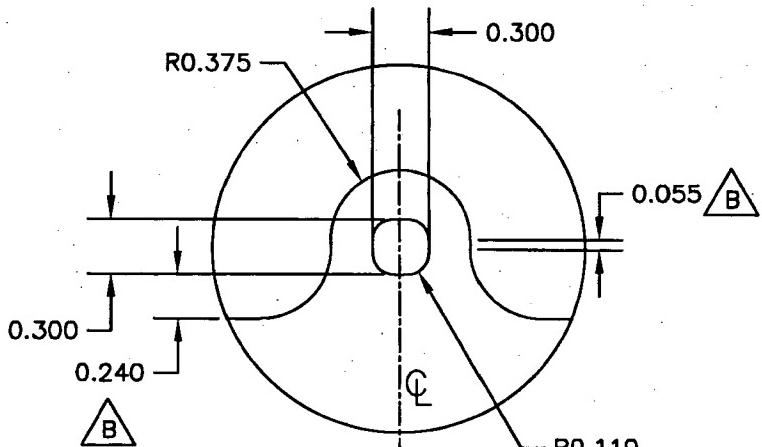
NOTES:  
 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
    20 GAUGE (0.038 THICK)  
    (REF DART SPEC M304S20GA)  
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
    QSI 005 4.3  
 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$   
 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
    OTHERWISE NOTED  
 5) ALL DIMENSIONS ARE IN INCHES  
 6) BREAK ALL SHARP EDGES TO 0.010 MAX  
 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
    PAINT MARKER  
 8) SEE PAGE 7 FOR DETAILS AND SECTION

UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *42328*

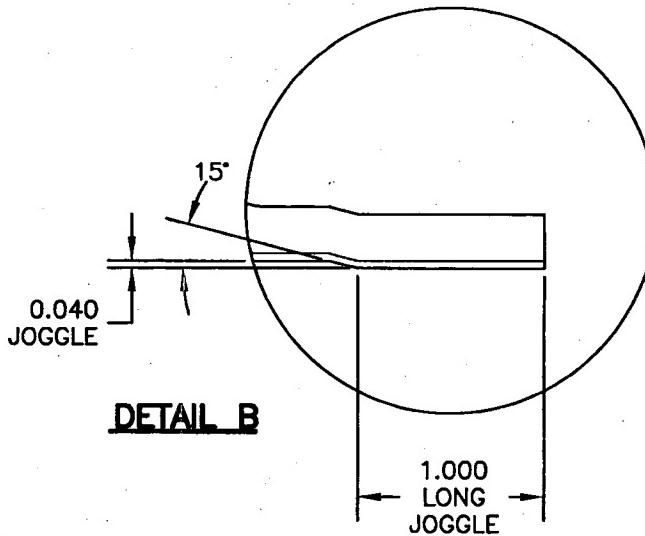
**DART**

RELEASED  
07.04.24

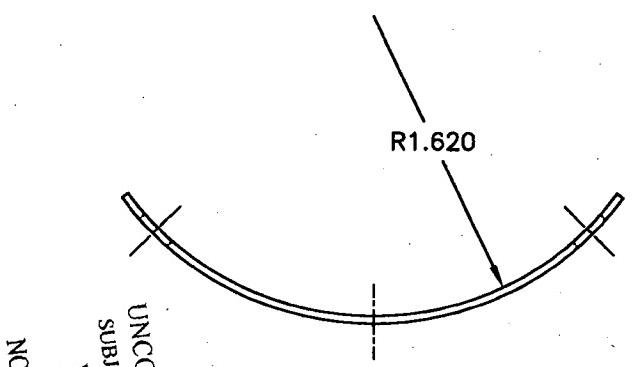
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	RH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		SHEET 7 OF 7
07.04.17		SCALE
		1:1



**DETAIL A**



**DETAIL B**



**SECTION C-C**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDERED  
NO. 2328